

D205-633.011

Work Order ID 51087

July 30, 2009 11:28:49 AM



Page 1

Item ID: D2563

Accept



Setup Start



Revision ID: C

Item Name: Step Weldment Assembly

Stop



Start Date: 7/31/09 Start Qty: 4.00



Cust Item ID:

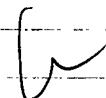
Required Date: 8/14/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:



Date: _____

Tooling: _____

Date: _____

Run Start



QC:

Date: _____

SPC (Y/N): _____

Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D2563 | Rev C |

100 0.00

Large Fab

Large Fab Memo 0.00

Large Fab
1-Cut D2244 to 89.70" at 34 deg as per dwg D2563 □ 2-Deburr ends □ 3-Weld (1
END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using
DT 8343 □ A/R AL ROD Batch: 330023 □ 4- Grind

110 0.00

QC9- Inspect visual per QSI004- Fusion Welds 0.00

QC Memo 0.00

Quality Control

120 0.00

QC5- Inspect part completeness to step on W/O 0.00

QC Memo 0.00

Quality Control

4
FL 09-07-30
M110130
M110494

A 09-08-04

2) S 09/08/04
(X4) f

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description**Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

SAD

09-08-04

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

150



Large Fab

Large Fab

0.00

Memo

0.00

1-Inspect for foreign object per QSI 024□2-Weld Remainig End as per Dwg
D2563 using DT 8343 □A/R AL ROD Batch: M110130

3-Grind

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 51087

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Item ID: D2563

Revision ID: C

Item Name: Step Weldment Assembly

Start Date: 7/31/09 Start Qty: 4.00

Required Date: 8/14/09 Req'd Qty: 4.00

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

PD 09-08-05

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

→ S 09/08/05

0.00

Memo

180



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

0.00

09-08-05

x4

M

* Touch up Alodine

Memo

Touch up Alodine then

2:30pm 320°F

□ START TIME:

3:00pm

FINISH

TIME:

320°F

TIME:

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Start Date: 7/31/09 Start Qty: 4.00



Cust Item ID:

Required Date: 8/14/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

190



HandFinish

Hand Finishing

Operation
Description

Pressure Wash per QSI005 4.3

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200



QC

Quality Control

QC3- Inspect Part Finish

0.00

BR 09-08-6

BR. ④

Memo

0.00

210 - Identify 3 Stock - See previous sheet. HJ

210 220



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/08/20 HJ

mf 09-08-19

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

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Page 1

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Work Order ID: 51087



Parent Item: D2563RevC



Parent Item Name: Step Weldment Assembly

Start Date: 7/31/09

Required Date: 8/14/09

Comments:

Start Qty: 4.00

Required Qty: 4.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

D2244-116RevD1



Manufactured

No

100

Each

61.0000

4.0000



Step Extrusion

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

61

33733

38023

3

58

1109-07-31

4

D2561RevB



Manufactured

No

100

Each

24.0000

8.0000



Lug

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

24

47177

24

1109-07-31

8

D2564RevB1



Manufactured

No

100

Each

63.0000

8.0000



Mounting Angle

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

63

45243

10

47966

53

1109-07-31

8

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 51087



Parent Item: D2563RevC



Parent Item Name: Step Weldment Assembly

Start Date: 7/31/09

Required Date: 8/14/09

Comments:

Start Qty: 4.00

Required Qty: 4.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2673-34RevB | | Manufactured | No | | | 100 | Each | 35.0000 | 8.0000 | | | |

End Plate



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

36406

35

35

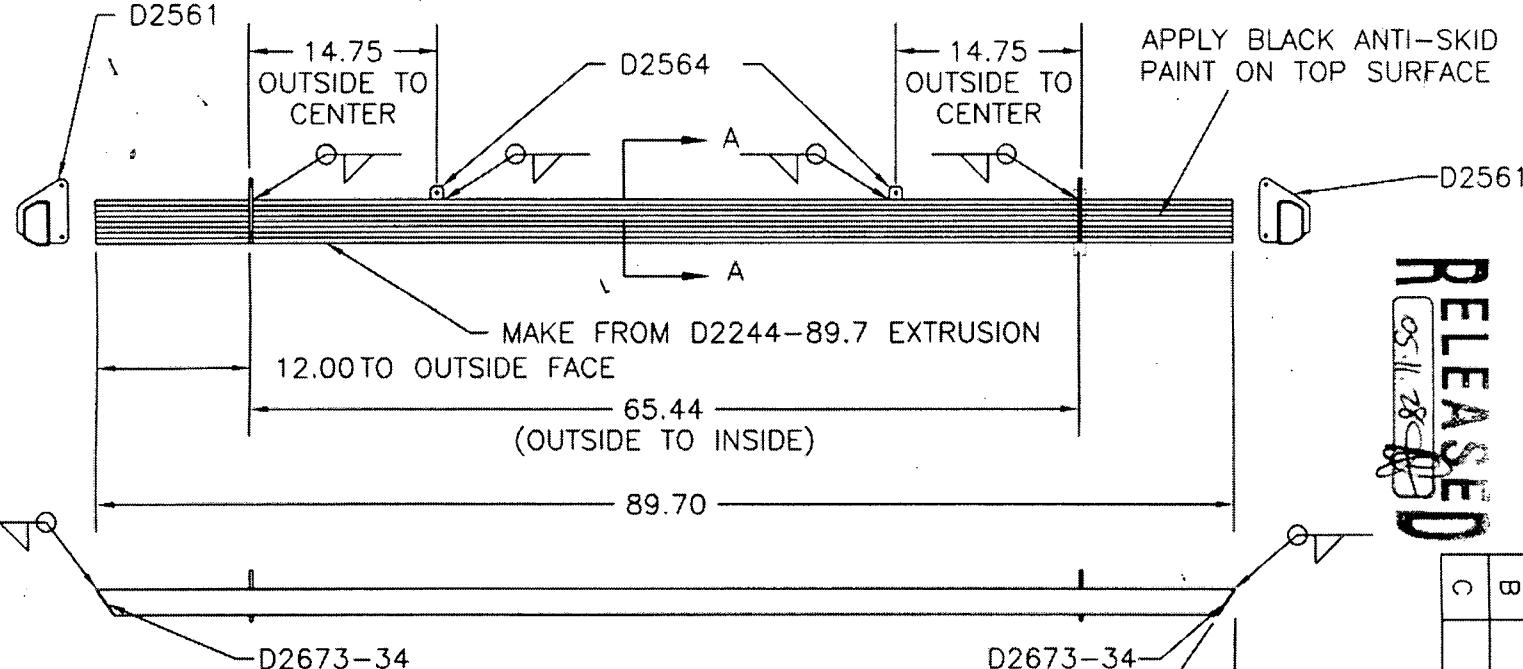
7/30/09-01-31 8

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

| Part No. | Description | QTY |
|------------|------------------------|-----|
| D2563 | STEP WELDMENT ASSEMBLY | X |
| D2244-89.7 | EXTRUSION* | 1 |
| D2561 | LUG PLATE | 2 |
| D2564 | MOUNTING ANGLE | 2 |

*cut per drawing

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05.11.28

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
REV. C
SHEET 1 OF 1
SCALE 1:15

| DESIGN BW | DRAWN BY <i>PF</i> | CHECKED <i>MM</i> | APPROVED <i>MM</i> | DRAWING NO. D2563 |
|------------------|-----------------------|------------------------------|-----------------------|---------------------------------|
| DATE 05.11.14 | | | | TITLE STEP WELDMENT ASSEMBLY |
| A | 96.04.26 | NEW ISSUE | | |
| B | 97.05.14 | END CAPS CHANGED (WAS D2248) | | |
| C | 05.11.14 | UPDATE NOTES | | |

*WJ
SLS/4*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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